

Date: Monday, 12/05/2008 3:45:57 PM
 User: Julie Lecocq

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	COBRA SKIDTUBE ASS'Y
Job Number :	39209		
Estimate Number :	13308		
P.O. Number :		Part Number :	D209669014
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D209-669-014
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JUD 08.5.12	Due Date :	23/05/2008
Comment :	New est. 08.02.13 new issue EC, verified by:DD		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D209-669-014 CHG002

08/05/20 08.5.13 JLD

2.0

39209A

COBRA SKIDTUBE ASS'Y



Comment: Sub-Component COBRA SKIDTUBE ASS'Y

ref Batch:

39209 A Sep

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

4.0

D29172

Saddle RH



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle LH

batch

B21360

AS 08/05/20 (x1)

5.0

D29182

Saddle RH



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle LH

batch

B21362 B

AS 08/05/20 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 3:45:57 PM
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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 39209

Part Number: D209669014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch

M107755

AS 08/05/20 (X)

7.0

D2570

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2570

Bushing

B37748

24

AS 08/05/20 (X)

8.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Nut

batch

M106051

AS 08/05/20 (X)

9.0

AN536A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch

M107715

AS 08/05/20 (X)

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch

M107534

AS 08/05/20 (X)

11.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch

M107464

AS 08/05/20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39209

Part Number: D209669014

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch

M107321

AS 08/05/20 (X1)

13.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch

M107321

AS 08/05/20 (X1)

14.0

D2929

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

batch

21295

AS 08/05/20 (X1)

15.0

D2930

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

batch

B21296

AS 08/05/20 (X1)

16.0

D27361

Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2736-1

Bracket

B37766

AS 08/05/20 (X1)

17.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-46A

Bolt

M107063

AS 08/05/20 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 39209

Part Number: D209669014

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D27363

Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2736-3 Bracket B37154

JS 08/05/20 (X)

19.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch B36322

JS 08/05/20 (X)

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch M107715

JS 08/05/20 (X)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/05/20 (X)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D209-669-014

Location: B

JS 08/05/20 (X)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/05/20 (X)

Job Completion



MF 08-05-29

B39209 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the replacement Dart parts. The weight and balance of the skidtubes that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D209-669-011/-012	49.6 lb	170.4 in	8452 in lb
SKIDTUBE INSTALLATION	22.5 kg	4.33 m	97.4 m kg
D209-669-013/-014	43.8 lb	176.5 in	7731 in lb
SKIDTUBE INSTALLATION	19.9 kg	4.48 m	89.2 m kg

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WITHOUT NOTICE
WORK ORDER
NO. 39209

5.0 PARTS LIST

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -041	Qty -043	Part Number	Description
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
1A						1	D2906-041	SKIDTUBE ASSEMBLY
1B						1	D2906-043	SKIDTUBE ASSEMBLY
2	1		2				D2917-1	OUTER SADDLE (FWD, LH)
3		1		2			D2917-2	OUTER SADDLE (FWD, RH)
4	1		2				D2918-1	INNER SADDLE (FWD, LH)
5		1		2			D2918-2	INNER SADDLE (FWD, RH)
6	1						D2919-1	OUTER SADDLE (AFT, LH)
7		1					D2919-2	OUTER SADDLE (AFT, RH)
8	1						D2920-1	INNER SADDLE (AFT, LH)
9		1					D2920-2	INNER SADDLE (AFT, RH)
10	8	8	8	8			AN4-51A	BOLT
11	16	16	16	16			D2570	BUSHINGS
12	8	8	8	8			MS21042L4	NUT (OR MS21042-4)
13	2	2	4	4			AN5-36A	BOLT
14	2	2					AN5-41A	BOLT
15	8	8	8	8			AN960JD516	WASHER
16	4	4	4	4			MS21042L5	NUT (OR MS21042-5)
17	16	16	16	16			AN4-7A	BOLT
18	32	32	32	32			AN960JD416	WASHER
19	16	16	16	16			MS21042L4	NUT (OR MS21042-4)

CONTINUED ON NEXT PAGE

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Revision: **B**
Date: 07.08.23

CONTINUED FROM PREVIOUS PAGE

20	2	2	2	2			D2929	SPACER
21	2	2	2	2			D2930	SPACER
*30A					1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
*30B					1	1	D3566-1	GASKET
*31A					1		D3564-15	WEARSHOE (REPLACES 18" D2577-5)
*31B					1		D3566-15	GASKET
*32A					1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
*32B					1	1	D3566-1	GASKET
*33A					1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
*33B					1	1	D3566-5	GASKET
*34					50	44	AN3C4A	BOLT (REPLACES AN3-4A)
*35					50	44	AN960C10L	WASHER (REPLACES AN960JD10L)
*36					50	44	AKS7-1032-130	INSERT (OR ALS7-1032-130, OR ALS4-1032-130, OR AKS4-1032-130)
*37					12	14	D2594-1	PLUG
*38					12	14	D2594-3	O-RING
*40					2	2	D2855	AFT CAP
*41					4	4	AN3-5A	BOLT
*42					4	4	AN960JD10L	WASHER
*43					4	4	AKS7-1032-225	INSERT (OR ALS7-1032-225, OR ALS4-1032-225, OR AKS4-1032-225)
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	LUG ASSEMBLY
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

* DENOTES THAT PART IS INCLUDED WITH D2906-041/-043 SKIDTUBE ASSEMBLY

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WORK ORDER
NO. 39209

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Revision: B
Date: 07.08.23

Date: Monday, 12/05/2008 3:49:44 PM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : COBRA SKIDTUBE ASS'Y
 Job Number : 39209A
 Estimate Number : 13181
 P.O. Number :
 This Issue : 12/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D209669043
 First Issue : 12/05/2008 Type : SKIDTUBES Drawing Number : D2906 REV.B
 Previous Run : 39206 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 23/05/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUL 08-5-12
 Comment : new est. 08.02.13 LL, verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D209-669 bluefile & type labels per PPP D205-669-041 chg 002

N/A *tg*

2.0 D25001190 Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2500-1-190 Skid Tube Extrusion 037544

DAL 8-5-13

3.0 D29263 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

batch 39225 SL 8-5-13

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2906 if necessary Deburrr ends

3-Acid etch and Alodine tube per QSI 005 4.1

KA

8-5-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: COBRA SKIDTUBE ASSY

Job Number: 39209A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-05-13

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	107604	
Sikaflex expire date: 8-7-31			
Start Time: 4:00		Date: 8-5-13	
Fin Time: 4:00 am		Date: 08-05-14	

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	89225

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program COB41FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg. D2906 & per template DT8185B & DT8185BC

RT/CL 08-05-14

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

SL 8-5-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39209A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/14 (P)

10.0

D2579

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
19	D2579	Spacers	238393 BE 08/05/15

238393 BE 08/05/15

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

m107263/m107877 BE 08/05/15

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Deburr holes

5-Drill pilot holes for aft & fwd cap using DT8025 open holes to #6" Deburr

6-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

283-22
PTO

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/22 (P)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-669-043 PAR #: N/A Fault Category: Prod/Schedule NCR: Yes No DQA: D Date: 08/05/20
 QA: N/C Closed: D Date: 08/05/20

NCR: <u>39209A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-05-20	11.0	Employee measured out the low ring hole, and drilled one side off by 1.00". Employee did not use drill jig D78091-3	<u>Res1412</u>	- Make a 6061-T6 plug - OD .640" X .150" thick. M <u>103857</u> - Weld plug into place & grind Flush per Q51004 Rev M <u>107877</u> drill AS per drawing	<u>08-05-20</u>	<u>S</u>	<u>Res1412</u>	<u>08-05-20</u>

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Part Number: D209669043

Job Number:



Seq. #: Machine Or Operation: Description :

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

BR 08-05-26 (1)

15.0 POWDER COATING

POWDER COATING



M107925



(IX)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320
9:30

M-L 08/05/27

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-05-27

17.0

D2855

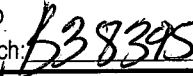
Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cap

Batch:



BR

18.0

AN35A

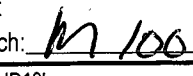
Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:



BR

19.0

AN960JD10L

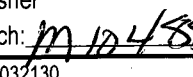
Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:



BR

20.0

ALS71032130

Insert

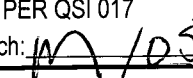


Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Insert

OR PER QSI 017

Batch:



BR

BR 08-05-27 (1)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN3C4A

BOLT



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

BOLT

Batch: M108077

BK

22.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: M108077

BK

23.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

O-Ring

Batch: B29908

BK

24.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Plug

Batch: B37926

BK

25.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

batch: B38408

BK

26.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

batch: B38518

BK

27.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

batch: B39235

BK

BK B-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 3:49:44 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 39209A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

batch

B34236

BL

29.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

batch

B38647

BL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M107804

Sikaflex expire date:

08-10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

M107804

Sikaflex expire date:

08-10

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch:

M107892

BL 08-05-28 ①

31.0

QCS

INSPECT WORK TO CURRENT STEP



S 08/05/28

Q



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Q

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D209-669-041

Location:

PPP

39209

8/5/28

SV

PPP Rev:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 3:49:44 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 39209A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29-1

Dart Aerospace Ltd

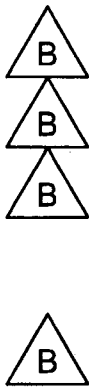
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER

NO. 39209

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07.09.04 *th*

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q7</i>	DART AEROSPACE LTD	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>q1</i>	D2906	SHEET 1 OF 3
APPROVED	<i>th</i>	TITLE	SCALE
DE APPR.	<i>th</i>	AH-1 (209) SKIDTUBE ASSEMBLY NTS	
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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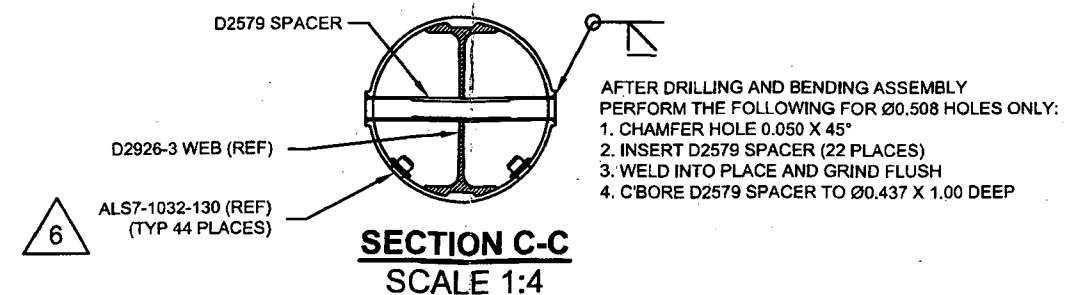
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D2906	SHEET 2 OF 3
APPROVED	<i>160</i>	TITLE	SCALE
DE APPR.	<i>21</i>	AH-1 (209) SKIDTUBE ASSEMBLY	1:24

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CHECKED	PH	DRAWING NO.	REV. 1
MFG. APPR.	90	D2906	SHEET 3 OF 3
APPROVED	90	TITLE	SCALE
DE APPR.	90	AH-1 (209) SKIDTUBE ASSEMBLY 1:2	
DATE 07.08.21		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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NO. 154

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 38940 A
Part number: D205 634 041
Description: Skid tube 205
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Del Duval Date of Test Coupon 0805-07
Welder Barclay Elliot Date of Test Coupon 08-05-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld